



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

STL

D2665-1

Job Sheet 172161



Part No: D2665-1

Job Qty: 4 ea

Part Name: Saddle, LH Fwd Aft Out



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/13/18

Job Tracking No:

Created By: Michelle Gagnon-Donovan

Due Date: 3/19/18

Description:

Type: Stock

Note: DWG REV D IPP: C 00.11.01 Removed P/O for Powder Coat - in house process EC IPP Rev:D As per Rev D 07-03-19 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		3/16/18	0.00	0.00	Start Up Machining-1		SBL 18/05/18
100	CNC Vertical Machining	4 pcs		3/17/18	1.75	6.15	HAAS1-2		SBL 18/05/13
110	Mill Conv	4 pcs		3/17/18	0.00	4.00	Mill Conv 1		SBL 18/05/13
120	QC	4 pcs		3/17/18	0.00	0.00	QC2 Machining-1		SBL 18/05/13
130	QC	4 pcs		3/17/18	0.00	0.00	QC8 Machining-1		
140	HandFinish	4 pcs		3/17/18	0.00	0.28	HandFinish1		BA 18-05-14
150	Powdercoat	4 pcs		3/19/18	0.00	0.20	Powdercoat1		CL / BEB 18-05-14
160	QC	4 pcs		3/19/18	0.00	0.00	QC3		38
170	Packaging	4 pcs		3/19/18	0.00	0.00	Packaging3-1		ST40 18-05-14
180	QC21-SA	4 Ea		3/19/18	0.00	0.00	QC21		MAY 16 2018

Part Op 100 - Program batch number. 1- Inspect part number and batch number are programmed correctly. 2- Machine Step No 1 Descriptions: of Folio and visually inspect as per attached Dimension Sheet 3- Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet

110 - Machine Keyway and inspect per attached dimension sheet

150 - START TIME: 10:40 AM OVEN TEMPERATURE: 320° FINISH TIME: 11:10 AM.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-003	Saddle Billet, 7075	4 Ea (1 ea)	90-Start up Operation	

5054514 → 5070834

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6101-003	4	50	0

Part Specifications

Specifications could not be found.

Plex 2/13/18 10:46 AM Dart.Gagnon.Michelle



Container No: S070835



Part: D2665-1

Job No: 172161

Serial No/Batch: S070835

Revision:

Inspector:

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Date: 05/12/10

DART AEROSPACE LTD		Work Order: 172 161
Description: 206 Saddle, Outboard, Left side		Part Number: D2665-1
Inspection Dwg: D2665	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		.122	.122	.121	.121	
B	0.100	0.140		.125	.125	.125	.125	
C	1.125	1.145		.882.135	.135	.135	.135	
D	0.615	0.685		.660	.660	.660	.660	
E	0.240	0.260		.243	.249	.249	.249	
F	1.313	1.343		.1315	.1320	.1320	.1320	
G	0.210	0.230		.213	.218	.218	.218	
H	0.100	0.180		.135	.135	.135	.135	
I	2.470	2.510		2.496	2.497	2.495	2.495	
J	1.565	1.585		.1575	.1575	.1575	.1575	
K	0.235	0.240		.238	.238	.238	.238	
L	0.100	0.120		.110	.110	.110	.110	
M	0.990	1.010		.1005	.1005	.1005	.1005	
N	0.510	0.515		.511	.511	.511	.511	
O	5.990	6.010		5.999	6.000	6.000	6.000	
P	1.245	1.255		.1250	.1250	.1250	.1250	
Q	2.495	2.505		2.500	2.500	2.500	2.500	
R	0.312	0.318		.312	.312	.312	.312	
S	0.315	0.322		.316	.316	.316	.316	
T	2.495	2.505		2.500	2.500	2.500	2.500	
U	1.357	1.367		.1363	.1362	.1362	.1362	
V	0.787	0.807		.797	.797	.797	.797	
W	0.540	0.560		.550	.550	.550	.550	
X	1.674	1.684		.1680	.1679	.1679	.1679	
Y	0.256	0.262		.257	.257	.257	.257	
Z	0.912	0.932		.922	.922	.922	.922	
AA	0.490	0.510		.501	.501	.504	.504	
AB	0.178	0.198		.188	.188	.188	.188	
AC								
AD								
AE								
Accept/Reject								

Measured by: SBL 18/05/12	Date: 18/05/12
Audited by: P 18-05-14	Date:
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.03.08	Dimension R and Y revised	KJ	M